Thursday, 7/19/2007 2:27:47 PM Date User: Kim Johnston **Process Sheet** : CU-DAR001 Dart Helicopters Services **Drawing Name** : SPACER Customer Job Number : 33670 : 10383 **Estimate Number** : D30661 Part Number P.O. Number : NA S.O. No. : N)A D3066 REV.B : 7/19/2007 **Drawing Number** This Issue Project Number : N/A Prsht Rev. : SMALL /MED FAB **Drawing Revision** First Issue : 33490 Material **Previous Run** : 8/3/2007 Each 60 Um: Due Date Qty: Written By Checked & Approved By Incorporated D3066-1 IPP KJ/RF Comment Est Rev:B Now M6061-T6 06-06-23 JLM **Additional Product** Job Number: Description: Seq. #: M6061T6S080 6061-T6 .080 Sheet 1.0 Comment: Qty.: 5.9535 sf(s) 0.0992 sf(s)/Unit Total : Material: 6061-T6 0.080" thick 57/07/28 WATER JET FLOW WATER JET 2.0 Comment: FLOW V 1-Cut as per Dwg D3066 Dwg Rev: Prog Rev: 60 3.0 PARTS AS THEY COME OFF MACHINE 60 SECOND CHECK 4.0 QC8 Comment: SECOND CHECK HAND FINISHING 5.0 Comment: HAND FINISHING RESOURCE #1 07.09-3 Chemical Conversion Coat as per QSI 005 4.1

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
			-							
				<u> </u>		-				

Part No:	 PAR #:	Fault Category:	 NCR: Yes No	DQA:	5	Date:	07/08/0
			QA: N/C	Closed:		Date:	

	WORK ORDER NON-CONFORMANCE (NCR)									
	Description of NC		Corrective Action Section E	1	Varification		Annroyal			
STEP	Section A			Sign & Date	Section C	Chief Eng	Approval QC Inspector			
						-				
	STEP	STED Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Verification Section C	STEP Description of NC Section A Section B Initial Action Description Sign & Verification Section C Chief Eng			

NOTE: Date & initial all entries

Thursday, 7/19/2007 2:27:47 PM Date: Kim Johnston User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: SPACER Ú Job Number: 33670 Part Number: D30661 Job Number: Description: Seq. #: Machine Or Operation: INSPECT POWDER COAT/CHEMICAL CONVERSION 6.0 QC3 Comment: INSPECT CHEMICAL CONVERSION COAT Comment: PACKAGING RESOURCE #1 Identify and Stock Location: QC21 8.0 Comment: FINAL INSPECTION/W/O RELEASE Jet-08.0/ Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector				
Part No	•	PAR #: Fault Category: NO	R: Yes	s No DQ	A:	Date: _					
			ΟΔ.	N/C Class	۸.	Doto					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	A 1	Approval			
DATE	STEP	Section A			Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
						1					

NOTE: Date & initial all entries

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DART AEROSPACE LTD	Work Order:	33670
Description: Spacer	Part Number:	D3066-1
Inspection Dwg: D3066 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	Х	First A	rticle	Prot	otype
Drawing	Α	ctual		D - : 4	Metho

Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
+0.005 -0.000	Ø0.130			Ven	
+/-0.010	0.703			Vern	
+/0.010	0.360		.,	Vern	
+/0.010	0.355			Vern	
+/-0.005	2.256	/		Vern	,
+/0.010	16:450			Mit /vern	11.7
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			- 4-		
	+0.005 -0.000 +/-0.010 +/0.010 +/0.010 +/-0.005	Tolerance Dimension +0.005 -0.000 +/-0.010 -/-0.010 -/0.010 -/0.010 -/-0.005 -/-0.005 -/-0.010 -/-0.010 -/-0.010 -/-0.005 -/-0.010 -/0.005 -/	Tolerance Dimension Accept +0.005 -0.000 Ø0.130 +/-0.010 0.703 +/0.010 0.360 +/-0.005 2.356 +/-0.010 /6:450	Tolerance Dimension Accept Reject +0.005 -0.000 Ø0.130 +/-0.010 0.366 +/0.010 0.355 +/-0.005 2.356 +/0.010 /6:450	Tolerance Dimension Accept Reject Inspection +0.005 -0.000 BO. 130 Vern +/-0.010 0.360 Vern +/0.010 0.355 Vern +/-0.005 2.356 Vern +/-0.005 16:450 Mern Mern

Measured by: SAL	Audited by:	Prototype Approval:	N/A
Date: 57/07/23	Date: 07/07/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.09.22	New Issue P/O D3065-041	KJ/RF	
В	06.06.23	Dwg Rev. changed	KJ/JLM	
			111	7.7



DESIGN DRAWN BY DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA APPROVED REV. B CHECKED DRAWING NO. D3066 SHEET 1 OF 1 DATE TITLE **SCALE** 06.05.29 **SPACER** 1:3 02.09.11 Α **NEW ISSUE** В 06.05.29 ADD 6061-T6 MATERIAL

- 0.000

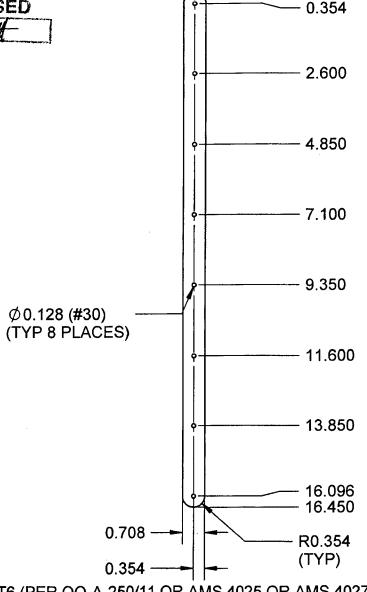
ENGINEERING

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

RELEASED



D3066-1 SPACER

1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR

OR

OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK

(REF DART SPEC. M5052H32S.080)

2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

4) PART IS SYMMETRIC ABOUT CENTERLINE

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES

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